



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D3953-21**  
**Job Sheet 172952**



**Part No:** D3953-21

**Job Qty:** 20 ea

**Part Name:** Gas Spring Bracket



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** Medium

**Job Created:** 2/23/18

**Job Tracking No:**

**Due Date:** 3/5/18

**Created By:** Logan David

**Type:** Stock

**Description:**

**Note:** DWG REV C IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg revC DD 10.03.02 verified by:EC

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|--------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                    |        |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 90    | Start up Operation | 20 Ea  |            | 3/3/18   | 0.00      | 0.00    | Start Up Waterjet     |           | SL 18/03/08 |
| 100   | Waterjet           | 20 pcs |            | 3/3/18   | 0.00      | 0.71    | Waterjet1             |           | SL 18/03/08 |
| 110   | QC                 | 20 pcs |            | 3/3/18   | 0.00      | 0.00    | QC2 Waterjet-3        |           | SL 18/03/08 |
| 120   | QC                 | 20 pcs |            | 3/3/18   | 0.00      | 0.00    | QC8-3                 |           | 38          |
| 130   | Small Fab          | 20 pcs |            | 3/5/18   | 0.00      | 0.67    | Small Fab-5           |           | 9-88        |
| 140   | QC                 | 20 pcs |            | 3/5/18   | 0.00      | 0.00    | QC5                   |           | 38          |
| 150   | Packaging          | 20 pcs |            | 3/5/18   | 0.00      | 0.00    | Packaging3            | ST-061    | 9-89        |
| 160   | QC21-SA            | 20 Ea  |            | 3/5/18   | 0.00      | 0.00    | QC21                  |           | 11-18-3-13  |

Part Op 100 - 1-Cut as per Dwg D3953  
Descriptions: 130 - 1- CHAMFER HOLE AS PER DWG

DAB  
21  
9-88

MAR 13 2018

### Job BOM

| Part / Item | Component Name      | Quantity            | Operation             | Container |
|-------------|---------------------|---------------------|-----------------------|-----------|
| M304S11GA   | 304/316 0.125 Sheet | .2880 sf (.0144 ea) | 90-Start up Operation |           |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | M304S11GA      | 0        | 3         | 0         |

### Part Specifications

Specifications could not be found.

Plex 2/23/18 11:09 AM dart.logan.david



**Container No: S049481**



**Part: D3953 - 21**

**Job No: 172952**

**Serial No/Batch: S049481**

**Revision:**

**Inspector:**

**DART Aerospace Ltd.**  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 813 632-6200  
Email: sales@dartaero.com  
www.dartaerospace.com

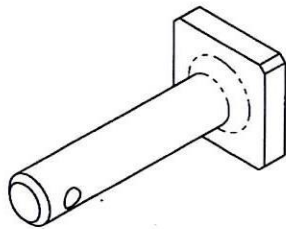
**Date: 03/09/18**



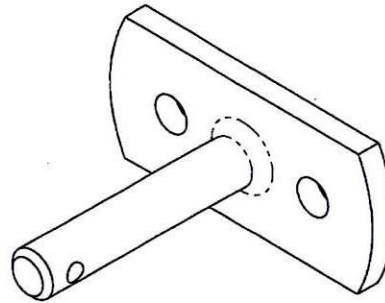




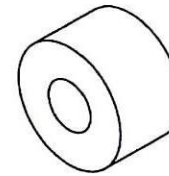
**D3953-1 GAS SPRING BRACKET**  
(FULL LID)



**D3953-3 GAS SPRING STUD, LID**



**D3953-5 GAS SPRING STUD, BASE**



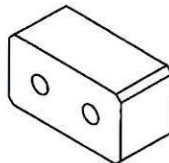
**D3953-7 GAS SPRING SPACER**



**D3953-9 GAS SPRING WASHER**



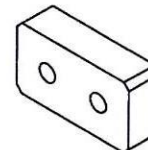
**D3953-11 GAS SPRING SPACER**



**D3953-13 GAS SPRING SPACER**  
(FULL LID)



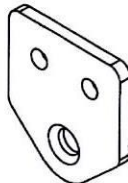
**D3953-15 GAS SPRING BRACKET**  
(SPLIT LID)



**D3953-17 GAS SPRING SPACER**  
(SPLIT LID)



**D3953-19 GAS SPRING BRACKET**  
(SQUARE BASKET)

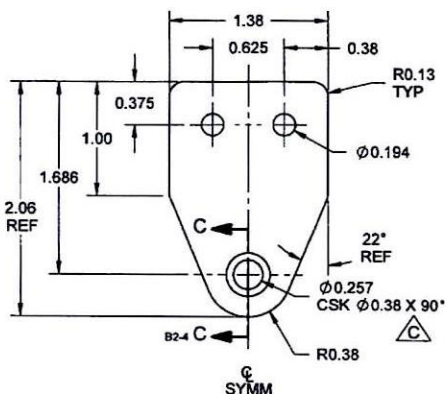


**D3953-21 GAS SPRING BRACKET**  
(SQUARE BASKET)

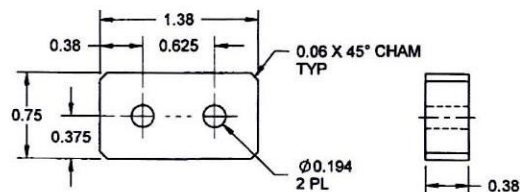
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WITHOUT NOTICE  
WORK ORDER  
NO. 172952  
20180226

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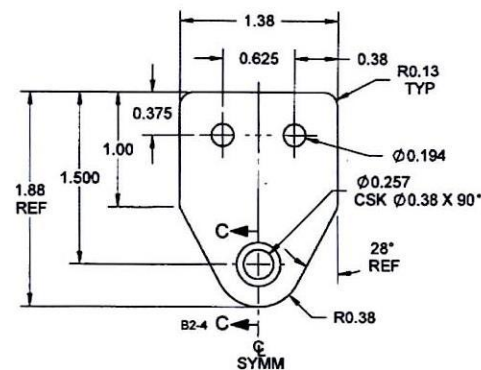
|            |                                                                                                                                                                                           |                                                                                                                                                                                                                                                                          |              |
|------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| C          | PARTS-19 & 21 ADDED (SHT 1 & 4); CSK CALLOUT WAS CHAM (C5-2, B5-3, C5-4); Q SYMM WAS Q SYMM ABOUT (C7-2, C7-4); SECTION C-C REPOSITIONED TO B2-4 REASON: ADDL PARTS REQD, DRAFTING ERRORS | JPH                                                                                                                                                                                                                                                                      | 10.01.29     |
| B          | SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED. REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.                                       | AJS                                                                                                                                                                                                                                                                      | 09.11.11     |
| A          | NEW ISSUE                                                                                                                                                                                 | AJS                                                                                                                                                                                                                                                                      | 09.07.27     |
| REV.       | DESCRIPTION                                                                                                                                                                               | BY                                                                                                                                                                                                                                                                       | DATE         |
| DESIGN     | AJS                                                                                                                                                                                       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                 |              |
| DRAWN      | JPH                                                                                                                                                                                       |                                                                                                                                                                                                                                                                          |              |
| CHECKED    | <u>JP</u>                                                                                                                                                                                 | DRAWING NO.                                                                                                                                                                                                                                                              | REV. C       |
| MFG. APPR. | <u>JP</u>                                                                                                                                                                                 | D3953                                                                                                                                                                                                                                                                    | SHEET 1 OF 4 |
| APPROVED   | <u>JP</u>                                                                                                                                                                                 | TITLE                                                                                                                                                                                                                                                                    | SCALE        |
| DE APPR.   | <u>JP</u>                                                                                                                                                                                 | GAS SPRING LID COMPONENTS                                                                                                                                                                                                                                                | NTS          |
| DATE       | 10.01.29                                                                                                                                                                                  | COPYRIGHT © 2009 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |



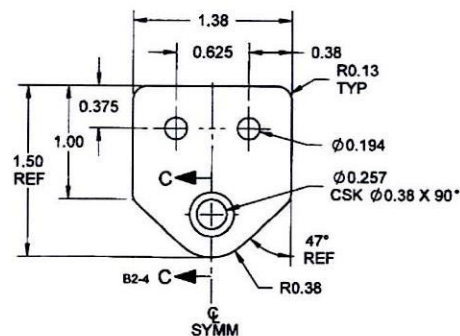
**D3953-15 GAS SPRING BRACKET**  
(SPLIT LID)



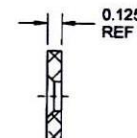
**D3953-17 GAS SPRING SPACER**  
(SPLIT LID)



**D3953-19 GAS SPRING BRACKET**  
(SQUARE BASKET)



**D3953-21 GAS SPRING BRACKET**  
(SQUARE BASKET)



**SECTION C-C**

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WORK ORDER  
NO. 172952 7L

20180226

**NOTES:**

1) MATERIAL -15/-19/-21: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5058 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA

-17: AISI 304 STAINLESS STEEL BAR  
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -15: 0.08 lbs

-17: 0.10 lbs

-19: 0.07 lbs

-21: 0.06 lbs

**DART AEROSPACE LTD**

HAWKESBURY, ONTARIO, CANADA

|            |          |
|------------|----------|
| DESIGN     | AJS      |
| DRAWN      | JPH      |
| CHECKED    |          |
| MFG. APPR. |          |
| APPROVED   |          |
| DE APPR.   |          |
| DATE       | 10.01.29 |

DRAWING NO.

D3953

TITLE

GAS SPRING LID COMPONENTS

SCALE

NTS

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